

Date: Wednesday, 29/04/2009 3:03:18 PM
 User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : SIDE DOOR
 Job Number : 47619
 Estimate Number : 12295
 P.O. Number :
 This Issue : 29/04/2009 S.O. No. :
 Prsht Rev. : NC
 First Issue : / / Type : PURCHASED PARTS
 Previous Run : 45404
 Part Number : D350589041
 Drawing Number : D2991 REV.C
 Project Number : N/A
 Drawing Revision : C
 Material :
 Due Date : 20/05/2009 Qty: 1 Um: Each
 Written By :
 Checked & Approved By : JUD 09.04.29
 Comment : est rev. A 06.02.16 new issue (was done on D350-589-041)
 EC
 Est Rev:B 08-02-20 ECN 1096 DD verified by:EC
 est rev C 08.06.26 Revised pik list per QC comment (w/o
 25885) EC verified: DD
 est rev D 09.02.18 ecn 09-523 , CHG 003 EC verified
 by:DD



Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 DC

DOCUMENT CONTROL



Schodis for JUD
09/05/11



Comment: DOCUMENT CONTROL

Photocopy bluefile & type labels per PPP D350-589-041

CHG003

CHG 004

PTD 09.05.11

2.0 OUTSIDE SERVICE

OUTSIDE SERVICES-ENGINEERING



Comment: Sub-Contracting OUTSIDE SERVICES

Issue P/O: 8723

Description: D2991-1 side door

Supplier: Delastek

Ship to delastek: Qty 2 D2992-1

Doubler

batch:

PTD 09.05.11
C209105104 ①
B46667 x2 C209105106 ②

Ensure batch # on Label D3721-1 match W/O # for D350-589-041

Certificate of Conformity and process sheet from Delastek is required

3.0

D29921

Doubler



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Doubler

N/A *INSTALLED AT*
Delastek

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
09.05.01	1	KITS NOW AT CHG 004 W/ 4.00" WIDE DZ992-1 DOUBLER				CP 09.05.16 pc QSI 042	09.06.19	
09.05.01	2	SHIP MODIFIED DZ992-1 DOUBLER 4.00" WIDE x 3.250' TALL x 0.040" THICK SUSZ-H32 W/ R0.250 CORNERS B/N 46667				CP 09.05.16 pc QSI 042	09.06.19	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 29/04/2009 3:03:19 PM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SIDE DOOR

Job Number: 47619

Part Number: D350589041

Job Number:



Seq. #:

Machine Or Operation:

Description:

4.0

D29911

Side Door



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)
Side Door

47619 343821

090618

5.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
Receive & Inspect For Transit Damage
Ensure certificate of conformity is attached

ENGINEERING
APPROVAL

09.06.19

6.0

QC6

DIMENSIONAL CHECK



Comment: Ensure Material certification comply to Dwg D2991

090618

7.0

D24641700

Neoprene Seal



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)
Pick:

Qty Part number Description Batch
1 D2464-1700 Foam seal

B48178

090620

8.0

D2585

Mounting Channel



Comment: Qty.: 3.0000 Each(s)/Unit Total: 3.0000 Each(s)
Pick:

Qty Part number Description Batch
4 D2585 Latch clamp

45888

PTO

9/6/14

SD

9.0

D2586

Door Latch



Comment: Qty.: 3.0000 Each(s)/Unit Total: 3.0000 Each(s)
Pick:

Qty Part number Description Batch
4 D2586 Door latch

45554

9/6/14

SD

10.0

D2621

Latch Plate, 350 Spacepod



Comment: Qty.: 3.0000 Each(s)/Unit Total: 3.0000 Each(s)
Pick:

Qty Part number Description Batch
4 D2621 latch plate

41175

9/6/14

SD

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod.Mgr	Approval QC Inspector
09.05.16	16	Add additional latch per DSI 9463 Rev.A.	<i>[Signature]</i>	090618	1	<i>[Signature]</i> 09.05.16	<i>[Signature]</i> 09.06.19

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 29/04/2009 3:03:19 PM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SIDE DOOR

Job Number: 47619

Part Number: D350589041

Job Number:



Seq. #:

Machine Or Operation:

Description :

11.0

D3085041

prop ass'y



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty	Part number	Description	Batch
1	D3085-041	prop ass'y	B 47186

9/6/16

SP

12.0

MS21042L3

Nut



Comment: Qty.: 6.0000 Each(s)/Unit Total: 6.0000 Each(s)

Pick:

Qty	Part number	Description	Batch
7	MS21042L3	Nut	M111274

9/6/16

SP

13.0

AN960JD10

Washer



Comment: Qty.: 3.0000 Each(s)/Unit Total: 3.0000 Each(s)

Pick:

Qty	Part number	Description	Batch
4	AN960JD10	Washer	M11027

9/6/16

SP

14.0

MS27039115

Screw



Comment: Qty.: 3.0000 Each(s)/Unit Total: 3.0000 Each(s)

Pick:

Qty	Part number	Description	Batch
4	MS27039-1-15	Screw	M110915

9/6/16

SP

15.0

D37211

Decal



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Decal

batch: 45492

9/6/16

SP

(R)

16.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble as per dwg D2991 & IIN D350-589 and install label as per dwg

SEE W/O CHD
9/6/16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SIDE DOOR

Job Number: 47619

Part Number: D350589041

Job Number:



Seq. #:

Machine Or Operation:

Description :

17.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Handwritten: 29.06.19 ①

18.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick list:

19.0

D38941

Switch Plate



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Switch Plate

Batch: *45526*

Handwritten: 5

Handwritten signature

20.0

D38951

Doubler



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Doubler

Batch: *46897*

Handwritten: 8

Handwritten signature

21.0

D2237

Striker Plate



Comment: Qty.: 3.0000 Each(s)/Unit Total : 3.0000 Each(s)

Pick:

Qty Part number Description Batch

4 8 D2237 Striker Plate

46162

Handwritten: 18.05.12

Handwritten signature

22.0

D2589

Keys, Key Chain, 350 Hinge



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part number Description Batch

1 D2589 keys, key chain

46840

Handwritten: 5

Handwritten signature

23.0

AN34A

Bolt



Comment: Qty.: 6.0000 Each(s)/Unit Total : 6.0000 Each(s)

Pick:

Qty Part number Description Batch

6 AN3-4A Bolt

M103915

Handwritten: 6

Handwritten signature and date: 9/5/19

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 29/04/2009 3:03:19 PM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SIDE DOOR

Job Number: 47619

Part Number: D350589041

Job Number:



Seq. #: Machine Or Operation: Description :

24.0 MS20470AD45 Rivet, Universal Head



Comment: Qty.: 80000 Each(s)/Unit Total : 80000 Each(s)
Pick:

Qty Part number Description Batch
8 MS20470AD4-5 Rivet M/09031

25.0 MS21042L3 Nut



Comment: Qty.: 3.0000 Each(s)/Unit Total : 3.0000 Each(s)
Nut M/11274

26.0 QC4 INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

27.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
Identify and Stock
Location:

★ ENSURE DSI 9463 RevA included
CP 09.05.16 GET FROM ENG IF NEEDED C2 09/06/19

28.0 QC21 FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



POSITIVE RECALL

EFFECTIVE 09.05.16 AUTH CP
RELEASED CP DATE 09.06.19

MF 09-06-19

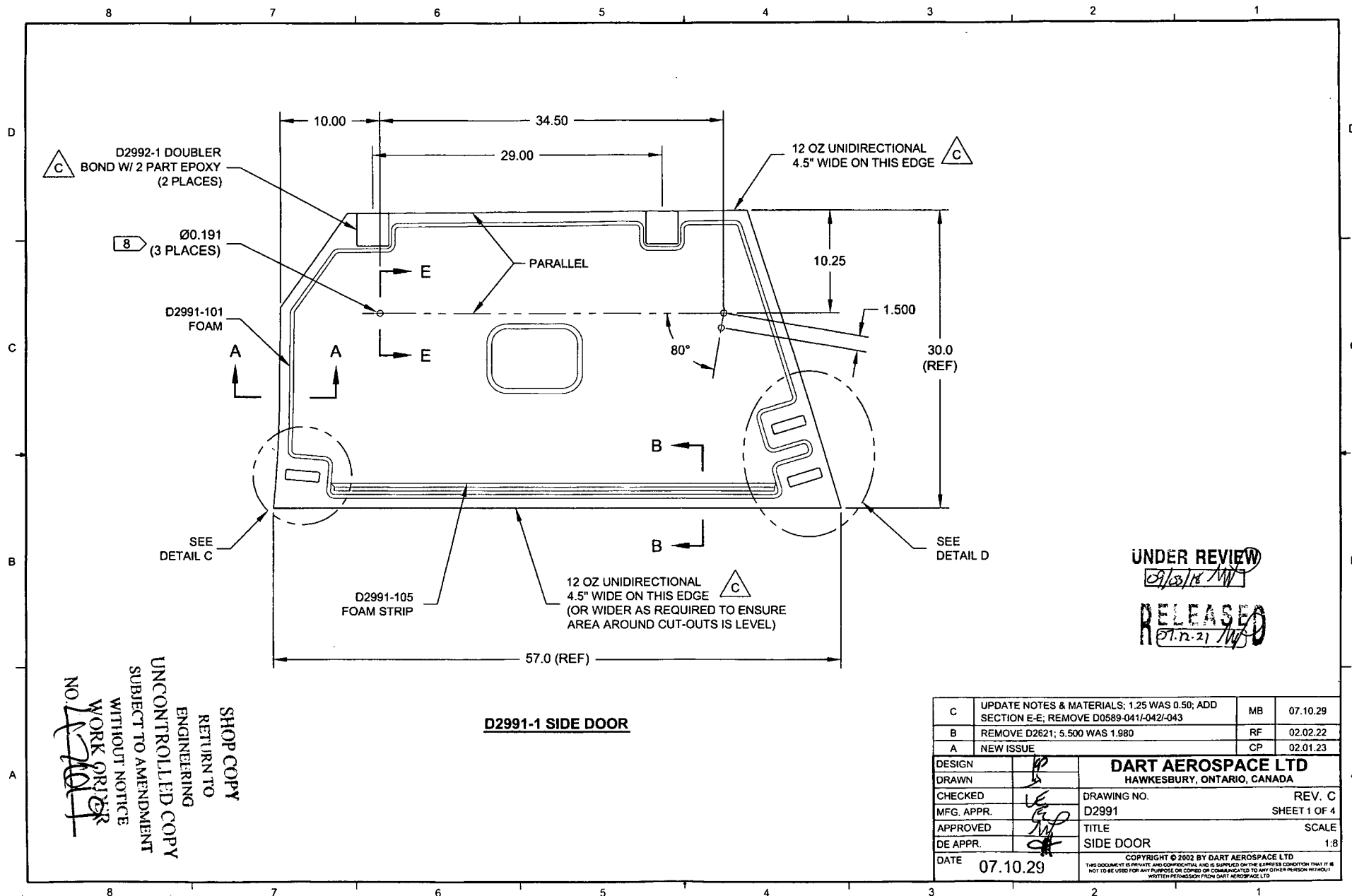
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

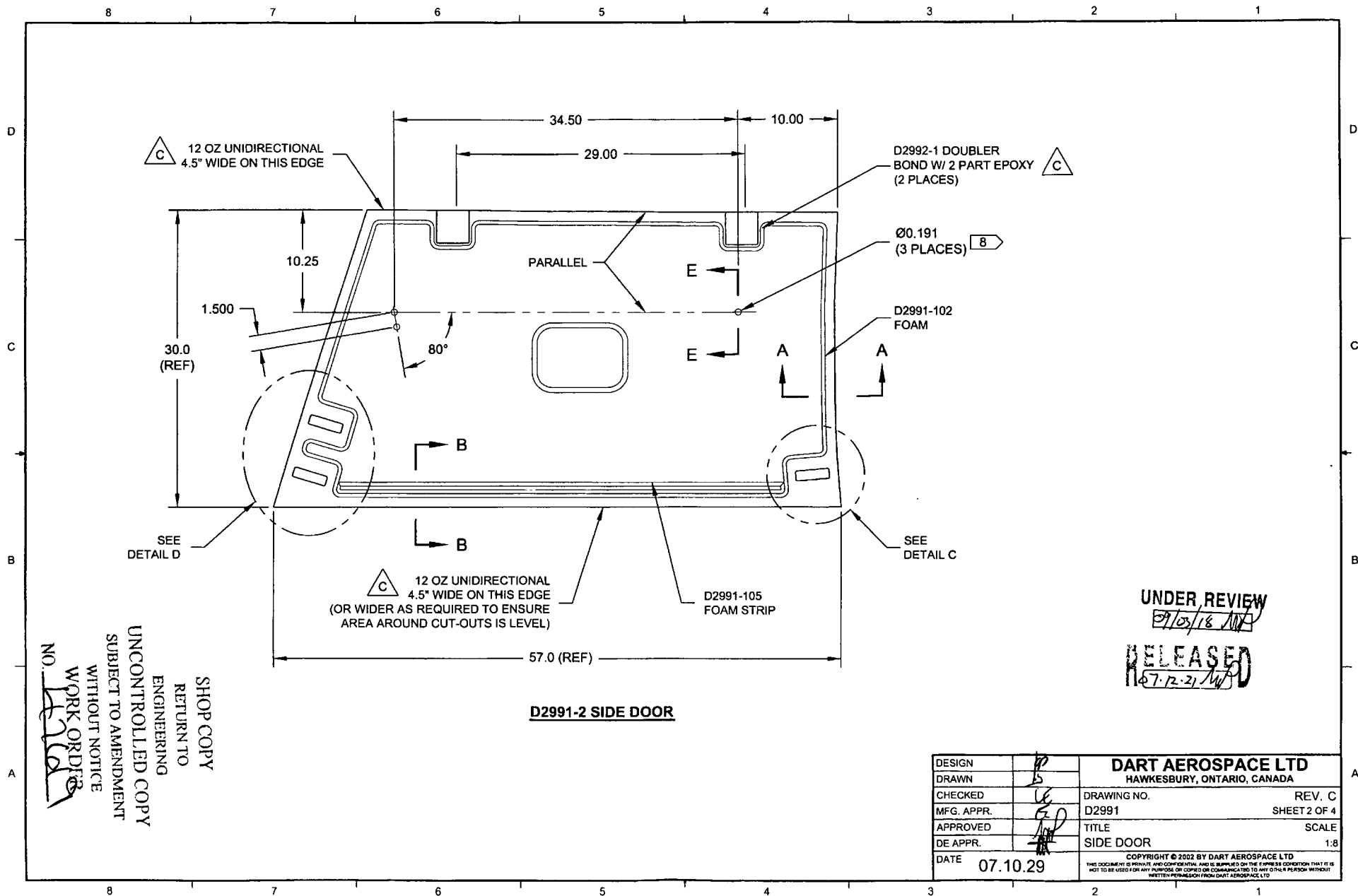


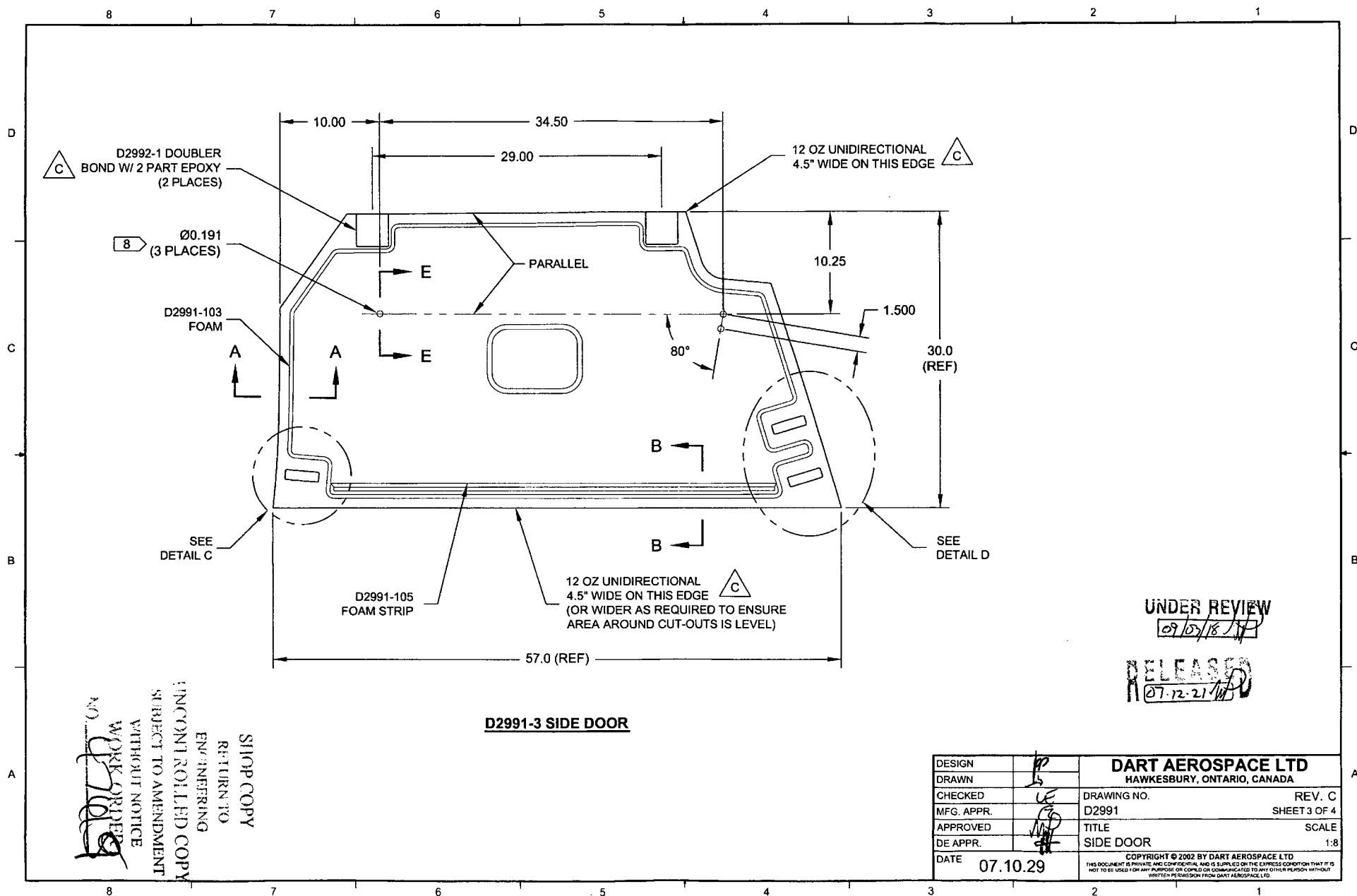
UNDER REVIEW
09/03/18
RELEASED
07.10.21

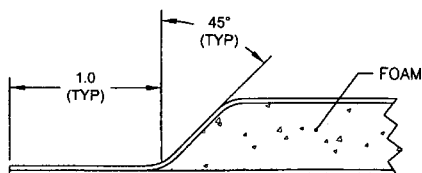
D2991-1 SIDE DOOR

C	UPDATE NOTES & MATERIALS; 1.25 WAS 0.50; ADD SECTION E-E; REMOVE D0589-041/-042/-043	MB	07.10.29
B	REMOVE D2621; 5.500 WAS 1.980	RF	02.02.22
A	NEW ISSUE	CP	02.01.23
DESIGN	RP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	LE		
CHECKED	LE	DRAWING NO.	REV. C
MFG. APPR.	LE	D2991	SHEET 1 OF 4
APPROVED	LE	TITLE	SCALE
DE APPR.	LE	SIDE DOOR	1:8
DATE	07.10.29	COPYRIGHT © 2002 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMBINED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

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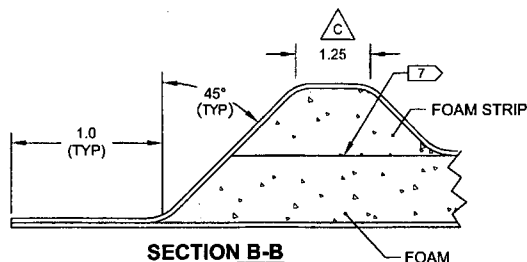






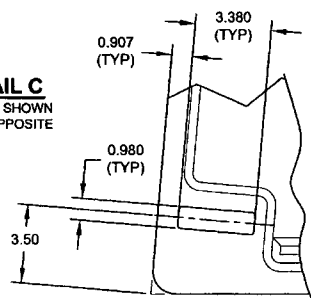
SECTION A-A

NOT TO SCALE
D2991-1/3 SHOWN
D2991-2 OPPOSITE



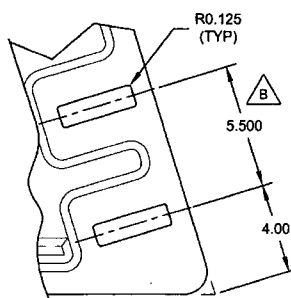
SECTION B-B

ONE EDGE ONLY
NOT TO SCALE, VIEW ROTATED
D2991-1/3 SHOWN
D2991-2 OPPOSITE



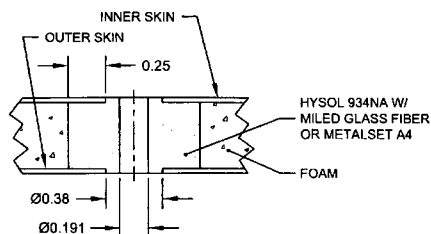
DETAIL C

D2991-1/3 SHOWN
D2991-2 OPPOSITE



DETAIL D

D2991-1/3 SHOWN
D2991-2 OPPOSITE



SECTION E-E

TYPICAL Ø0.191
HOLE DETAIL
NOT TO SCALE

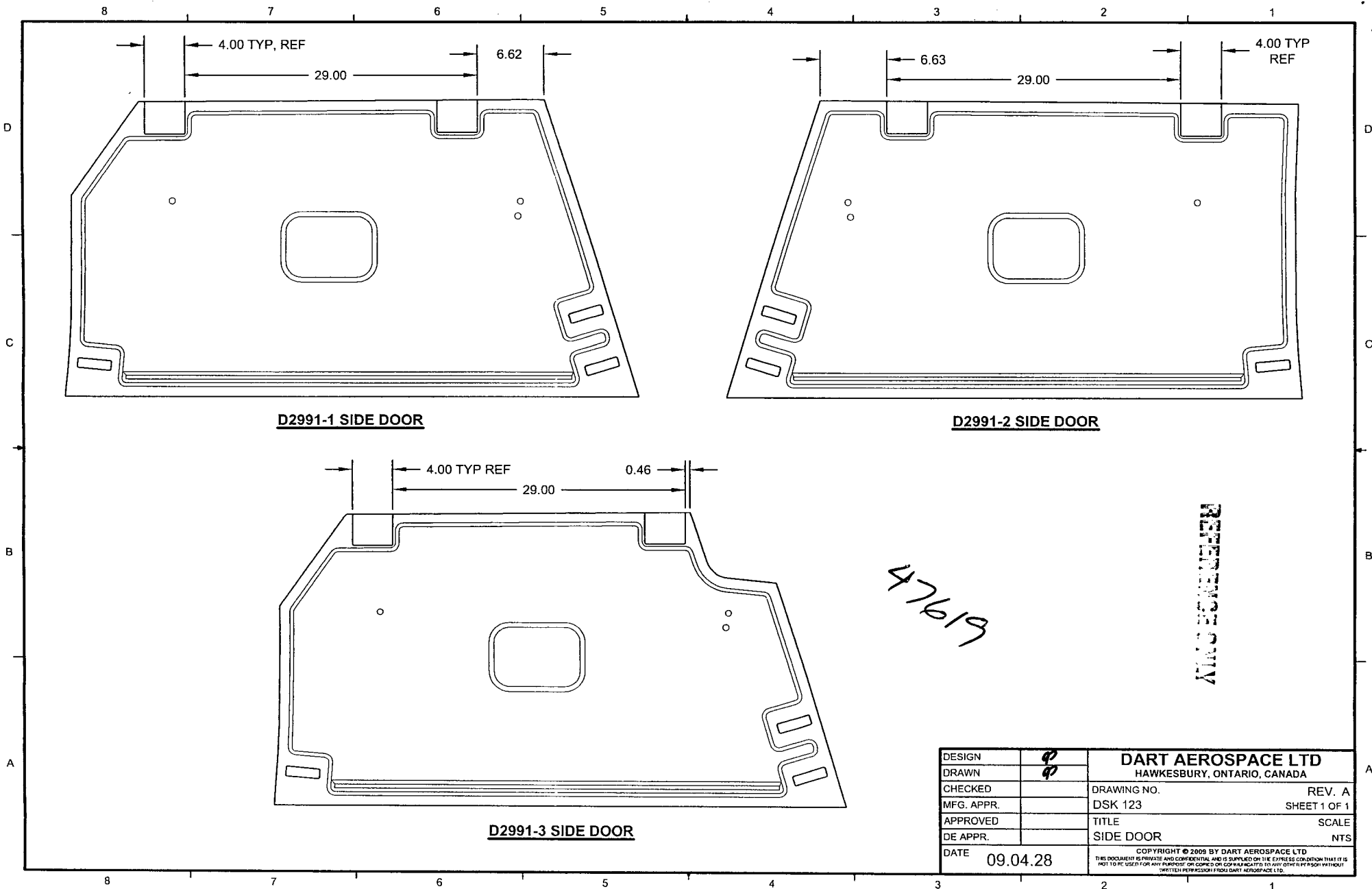
NOTES FOR D2991-1/-2/-3

- 1) LAYUP PER QSI 006 AND AS FOLLOWS
- 2) MATERIALS:
RESIN: EPOCAST 50-A/9816 OR DERAKANE 470-36/411/510A40
FOAM: 3/8", A500 CORE-CELL OR DIVINYCELL OR AIREX OR KLEGECELL
FIBRE: 9.7 OZ 7781 WEAVE "S" GLASS ("9 OZ SATIN")
12 OZ UNIDIRECTIONAL FIBERGLASS ("12 OZ UNIDIRECTIONAL")
- 3) FINISH INSIDE WITH DUPONT HIGHBUILD PRIMER GREY #1104S OR #1144S
- 4) USE MOLD DT8626 FOR D2991-1 SIDE DOOR
USE MOLD DT8627 FOR D2991-2 SIDE DOOR
USE MOLD DT8626 FOR D2991-3 SIDE DOOR (TRIM PER DT8631)
- 5) ROUTER FOAM CORE USING: DT8628 FOR D2991-1 SIDE DOOR
DT8628 FOR D2991-2 SIDE DOOR
DT8630 FOR D2991-3 SIDE DOOR
- 6) MAIN LAYUP: WHITE GLOSS GELCOAT #GEL 944W005
9 OZ SATIN
9 OZ SATIN
FOAM
FOAM STRIP
9 OZ SATIN
12 OZ UNIDIRECTIONAL (4.5" WIDE, 2 EDGES SHOWN)
9 OZ SATIN
RESIN (35-45% BY WEIGHT)
PEEL PLY
- 7) BOND FOAM CORE USING POLYBOND B46F
- 8) DRILL Ø0.38 HOLE. REMOVE THE FOAM INNER LAYER 0.25 AROUND THE HOLE BETWEEN THE INNER AND OUTER SKINS. APPLY TAPE OR AN EQUIVALENT BACKER TO THE INNER SIDE OF THE HOLES TO PREVENT EPOXY FILLER FROM GOING THROUGH. FILL THE CAVITY BETWEEN THE SKINS COMPLETELY WITH HYSOL 934NA MIXED WITH MILLED GLASS FIBERS TO A RATIO OF 10:1 OR METALSET A4. ALLOW THE MATERIAL TO CURE. DRILL Ø0.191 THROUGH, 3 PLACES PER DOOR. SEE SECTION E-E.
- 9) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 10) UNITS: INCHES UNLESS OTHERWISE NOTED
- 11) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 12) IDENTIFICATION: PER D2991-1/-2/-3 PPPs.
- 13) WEIGHT: 9 lbs (TYP)

UNDER REVIEW
07/12/18
RELEASED
07.12.21

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG APPR.		D2991	SHEET 4 OF 4
APPROVED		TITLE	SCALE
DE APPR.		SIDE DOOR	1:
DATE	07.10.29	COPYRIGHT © 2002 BY DART AEROSPACE LTD	
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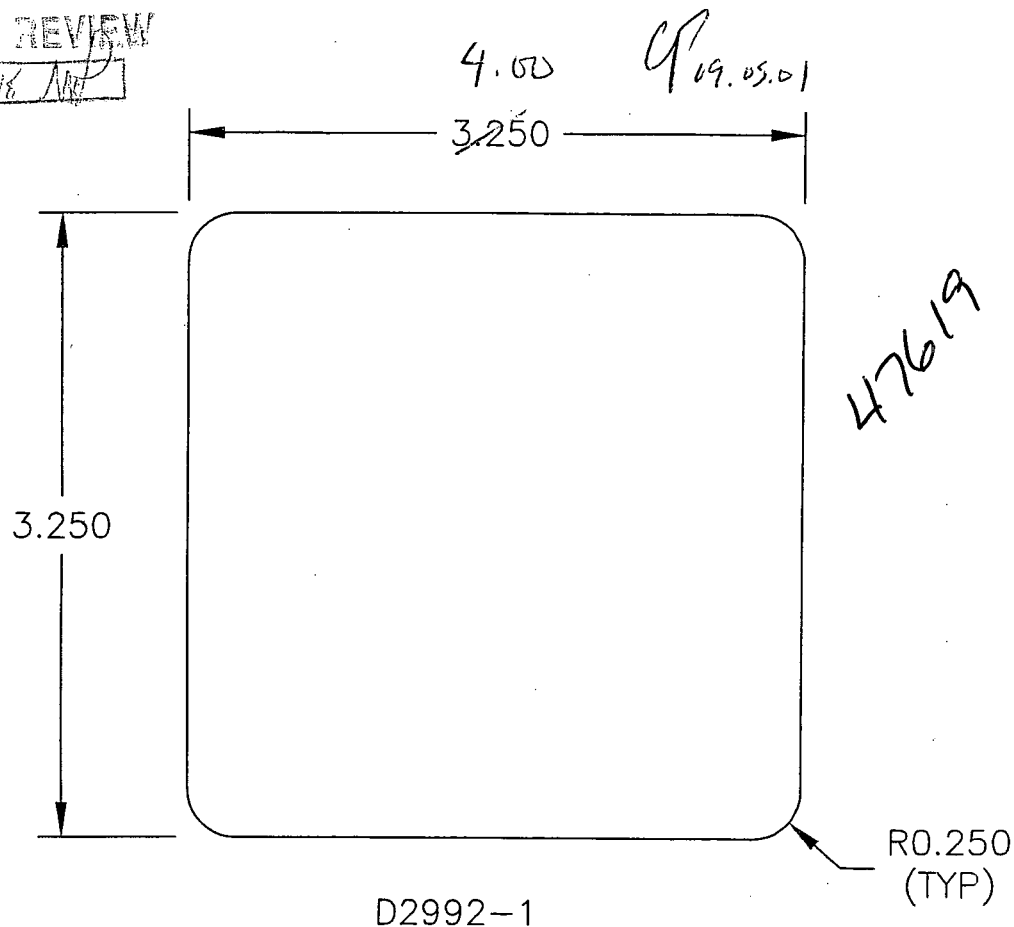


DESIGN CP	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED H	APPROVED H	DRAWING NO. D2992	REV. A SHEET 1 OF 1
DATE 02.01.21		TITLE DOUBLER	SCALE 1:1
A	02.01.21	NEW ISSUE	

RELEASED
02.01.21 H

UNDER REVIEW
07/03/16 H

REFERENCE C



NOTES:

MATERIAL: 5052-H32 (QQ-A-250/8) 0.040 THICK

FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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DELASTEK COMPOSITES INC.
2699, 5^{ème} Avenue
Local 14, PORTE -A-
Grand-Mère, Québec G9T 5K7
Can **Fax (819) 533-3494 **

PACKING SLIP CERTIFICATE OF COMPLIANCE

Invoice #	13183
Customer #	DART

Telephone: (819) 533-5788

Warehouse: MAIN

Bill to:

Dart Aerospace Ltd.
1270, Aberdeen Street
Hawkesbury, Ontario K6A 1K7
Canada

Ship to:

Dart Aerospace Ltd.
1270, Aberdeen Street
Hawkesbury, Ontario K6A 1K7
Canada

Telephone: 613-632-5200

Contact: Linda Lacelle

Ship via		F.O.B.		Terms		Salesperson	
EPIC EXPRESS COLLECT		Origin		Net30 days		Claude Lessard, ext. 233	
Ship date	Order Date	Our PO #	Order by		Your PO #	GST/PST #	
12/06/2009	04/05/2009	6010	Chantal Lavoie		PO00008723		
Order Qty	B.O. Qty	Current Ship.	Item #	Item Description			
1	0	1	DKC134-0050	Side Door N° D2991-1 B47619 U de M : Each Dwg.: D2991 Rév.: C annoté Job: 43821			
1	0	1	DKC134-0051	Side Door N° D2991-2 B47621 U de M : Each Dwg.: D2991 Rév.: C annoté Job: 43823			

It is hereby certified that all materials, process and finished items were controlled and tested in accordance with the requirements of the purchase order and applicable specifications. All such records are on file at our plant and available for review upon request.

☒ Cust. ☐ Adm. ☐ Quality ☐ Ship.

Accepted by:

Quality department

AQ-357



Date: Lundi, 2009-06-01 11:09:47
 Utilisateur: Marc Dubé

Feuille de Procédé

 Client : DART Dart Aerospace Ltd.
 Numéro Job : 43821
 Numéro Soumission : 2622
 Numéro B.A. :
 Cette fois : 2009-06-01 No. B.V. :
 Prsht Rev. : NC
 Prem. fois : - - Type :
 Job précédente : 43805

 Nom Dessin : SIDE DOOR N° D2991-1 **G**
 Numéro Article : DKC134-0050
 Numéro Dessin : D2991
 Projet Numéro : DKC134
 Révision dessin : C
 Matériel : Composites
 Date Dûe : 2009-06-08

Qté: 1 Udm: UNITE

 Écrit par :
 Vérifié & Approuvé par :
 Commentaires : N° de pièce Client: D2991-1

 Process Sheet Rev.: 01 Remplacer Frekote 700 NC par Loctite
 Frekote Wolo et ajouter espace de N° de Lot pour les articles
 AACxxxx.

Produit additionnel

Numéro Job:



# Séq.:	Machine ou Opération:	Description :
1.0	AAC0700	N° 83634, Frekote Loctite Wolo

 Commentair Qty.: 0.025 UNITE(s)/Unit Total : 0.025 UNITE(s)
 N° 83634, Frekote Loctite Wolo N° de Lot:

2.0	PRÉPARATION 3	PRÉPARATION DU MATÉRIEL DART
-----	---------------	------------------------------



Commentair Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 0.0833Hrs

Faire la préparation du moule N° DKO-0094 laisser sécher pendant 3 heures selon le QSI-006 et IG 0009.

Date: Sceau:

3.0	AAC0273	Gel Coat Blanc N° Gel 944W005
-----	---------	-------------------------------

 Commentair Qty.: 1.000 KILOGRAMME(s)/Unit Total : 1.000 KILOGRAMME(s)
 Gel Coat Blanc N° Gel 944W005 N° de Lot: ~~1-22176-1~~ 1-7047-1


4.0	AAC0275	Catalyst N° DDM-9
-----	---------	-------------------

 Commentair Qty.: 0.0250 UNITE(s)/Unit Total : 0.0250 UNITE(s)
 Catalyst N° DDM-9 N° de Lot: 1-22176-1

5.0	AAC0198	UN2055 styrene monomere ST
-----	---------	----------------------------

 Commentair Qty.: 0.014 GALLON(s)/Unit Total : 0.014 GALLON(s)
 UN2055 styrene monomere ST N° de Lot:

6.0	PRÉPARATION 3	PRÉPARATION DU MATÉRIEL DART
-----	---------------	------------------------------



Commentair Setup: 0.00Hrs/ Run: 15.0000Min Total Run : 0.2500Hrs

 Dans une quantité de 0.2 gallon de Gel Coat N° 944W005 ajouter 2% de Catalyst N° DDM-9 et diluer à
 l'aide de 5% de UN2055 styrene monomere ST

Date: Lundi, 2009-06-01 11:09:47
Utilisateur: Marc Dubé

Feuille de Procédé

Client: DART Dart Aerospace Ltd.
Numéro Job: 43821

Nom Dessin: SIDE DOOR N° D2991-1
Numéro Article: DKC134-0050

Numéro Job:



Séq.: Machine ou Opération: Description :
Date: 29-5-09 Sceau: 34 Temps Début: 9:00 Temps Fin: 9:15

7.0 GEL COAT. APPLICATION DE GEL COAT



Commentaire Setup: 0.00Hrs/ Run: 15.0000Min Total Run : 0.2500Hrs
APPLICATION DE GEL COAT

Faire l'application du Blanc N° Gel 944W005 sur le moule N° DKO-0094 selon l'instruction Générale de fabrication N°IG 0019

Date: 29-5-09 Sceau: 34



8.0 AC0409 Tissu à délaminer Release ply B

Commentaire Qty.: 5.43 VERGE(s)/Unit Total : 5.43 VERGE(s)
Tissu à délaminer Release ply B

9.0 AC0407 Wrightlon 5200 Bleu P3

Commentaire Qty.: 5.43 VERGE(s)/Unit Total : 5.43 VERGE(s)
Wrightlon 5200 Bleu P3

10.0 AC0408 Feutre de drainage N° Airweave N 10

Commentaire Qty.: 5.43 VERGE(s)/Unit Total : 5.43 VERGE(s)
Feutre de drainage N° Airweave N 10

11.0 AC0752 Stretchlon 200 poche à vide Vert

Commentaire Qty.: 12.00 PIED(s)/Unit Total : 12.00 PIED(s)
Stretchlon 200 poche à vide Vert

12.0 AAC0276 Fiberglass 9oz Type "S" N° FG778138-125Y

Commentaire Qty.: 7.30 VERGE(s)/Unit Total : 7.30 VERGE(s)
Fiberglass 9oz Type "S" N° FG778138-125Y N° de Lot: 1-7080-1

13.0 AAC0443 Fiberglass 12 oz Unidirectional

Commentaire Qty.: 4.00 VERGE(s)/Unit Total : 4.00 VERGE(s)
Fiberglass 12 oz Unidirectional N° de Lot: 1-21729-1

14.0 AC0098 Ruban à gommer jaune #: T/AT-200Y

Commentaire Qty.: 3.0000 RL(s)/Unit Total : 3.0000 RL(s)
Ruban à gommer jaune #: T/AT-200Y

15.0 PRÉPARATION 3 PRÉPARATION DU MATÉRIEL DART



Commentaire Setup: 0.00Hrs/ Run: 20.0000Min Total Run : 0.3333Hrs
PRÉPARATION DU MATÉRIEL DART

Tailler le matériel, selon les différents patrons de découpe comme suit:

4 plis de tissus de 9.7 oz.

1 pli de 12 oz. pour tout le contour de la pièce par 5" de large.

3 fois le sac à vide Stretchlon 200.

Feuille de Procédé

Client: DART Dart Aerospace Ltd.
Numéro Job: 43821

Nom Dessin: SIDE DOOR N° D2991-1
Numéro Article: DKC134-0050

Numéro Job:



Séq.: Machine ou Opération: Description :

Faire la poche à vide en appliquant les composantes dans l'ordre ui suit:

- 1- Tissu à délaminer.
- 2- Film Perforé P-3.
- 3- Feutre de drainage
- 4- Sac à vide Stretchlon 200

Laisser sécher pendant 4 heures minimum.

Date: 29-5-09 Sceau: N.T.

Curing début: 12:35 Curing Fin: 8:00

21.0 AAC0452 Polybond B46F

Commentair Qty.: 0.143 KIT(s)/Unit Total: 0.143 KIT(s)
Polybond B46F N° de Lot: 1-6986-1

22.0 DKC134-0062 Foam Core N° D2991-101 (Porte D2991-1)

Commentair Qty.: 1 UNITE(s)/Unit Total: 1 UNITE(s)
Foam Core N° D2991-101 (Porte D2991-1) N° de Lot: 43818

23.0 ASSEMBLAGE 3 ASSEMBLAGE GÉNÉRALE DART



Commentair Setup: 0.00Hrs/ Run: 15.0000Min Total Run: 0.2500Hrs
ASSEMBLAGE GÉNÉRALE DART

Retirez le bagging.

Appliquer une couche de polybond B64F à l'endos du foam core N° DKC134-0062 et positionner le foam sur le moule selon le dessin et selon les lignes de positionnement prévues à cet effet.

Date: 5-6-09 Heure Début: 10:20 Heure Fin: 10:40 Sceau: N.T.

24.0 POCHÉ À VIDE 1 FAIRE LA POCHE À VIDE



Commentair Setup: 0.00Hrs/ Run: 10.0000Min Total Run: 0.1667Hrs
FAIRE LA POCHE À VIDE

Faire la poche à vide en appliquant les composantes dans l'ordre suivant:

- 1- Film Perforé P-3.
- 2- Feutre de drainage
- 3- Sac à vide Stretchlon 200.

Laisser sécher pendant 2 heures minimum.

Date: 5-6-09 Sceau: N.T.

Feuille de Procédé

Client: DART Dart Aerospace Ltd. Nom Dessin: SIDE DOOR N° D2991-1
Numéro Job: 43821 Numéro Article: DKC134-0050



Numéro Job: 


Séq.: Machine ou Opération: Description :



25.0 AAC0274 Derakane 411-350 Promoté N° RV411B3020
Curing Début: 10:20 Curing Fin: 11:45


Commentair Qty.: 1.700 KILOGRAMME(s)/Unit Total: 1.700 KILOGRAMME(s)
Derakane 411-350 Promoté N° RV411B3020 N° de Lot: 1-24224-1



26.0 AAC0275 Catalyst N° DDM-9
Commentair Qty.: 0.0040 UNITE(s)/Unit Total: 0.0040 UNITE(s)
Catalyst N° DDM-9 N° de Lot: 1-22176-1

27.0 PRÉPARATION 3 PRÉPARATION DU MATÉRIEL DART
 

Commentair Setup: 0.00Hrs/ Run: 5.0000Min Total Run: 0.0833Hrs
PRÉPARATION DU MATÉRIEL DART
Faire la préparation de la résine selon les quantités requises, mix ratio 2% de catalyst N° DDM-9 par quantité de résine N° 411-350.
Date: 9-6-09 Heure Début: 9:10 Heure Fin: 9:15 Sceau: 

28.0 LAMINAGE. LAMINAGE PIÈCE DART
 

Commentair Setup: 0.00Hrs/ Run: 30.0000Min Total Run: 0.5000Hrs
LAMINAGE PIÈCE DART
Faire le laminage d'un pli de 9.7 oz.
Faire le laminage du plis de tissu 12 oz. tout le tour de la porte en prenant bien soin que les deux bandes allant dans le coin droit en bas se superposent
Faire le laminage du dernier pli de 9.7 oz.
Date: 9-6-09 Heure Début: 9:15 Heure Fin: 10:00 Sceau:  N.T.

29.0 POCHÉ À VIDE 1 FAIRE LA POCHÉ À VIDE
 

Commentair Setup: 0.00Hrs/ Run: 10.0000Min Total Run: 0.1667Hrs
FAIRE LA POCHÉ À VIDE
Faire la poche à vide en appliquant les composantes dans l'ordre suivant:
1- Tissu à délaminer.
2- Film perforé P-3.
3- Feutre de drainage
4- Sac à vide Stretchlon 200.
Laisser sécher pendant 4 heures minimum.

Feuille de Procédé

Client: DART Dart Aerospace Ltd. Nom Dessin: SIDE DOOR N° D2991-1
Numéro Job: 43821 Numéro Article: DKC134-0050

Numéro Job:



Séq.: Machine ou Opération: Description :

Date: 9-6-09 Heure Début: 10:00 Heure Fin: 10:10 Sceau: N.T.

Curing Début: 9:15 Curing Fin: 3:30

30.0 DÉMOULAGE 1

DÉMOULAGE PIÈCE DART



Commentair Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 0.0833Hrs
DÉMOULAGE PIÈCE DART

Démouler la pièce en faisant bien attention de ne pas abimer les coins et les " edges ". Selon l'instruction générale de fabrication N° IG 0018

Date: 13-6-09 Sceau: N.T.

31.0 TRIMAGE 3

TRIMAGE COMPOSITES DART



Commentair Setup: 0.00Hrs/ Run: 30.0000Min Total Run : 0.5000Hrs
TRIMAGE COMPOSITES DART

À l'aide du gabarit N° DKO-0118 trimer la pièce en utilisant un router muni d'un couteau 1/4" et d'un " Bushing " 1/16" de mur.

Percer les " Latch " et les trous de penture selon le dessin N° D2991.

Date: 10-6-09 Sceau: N.T.

32.0 AAC0701

Araldite 2043

pour les insert seulement

Commentair Qty.: 0.150 UNITE(s)/Unit Total : 0.150 UNITE(s)

Araldite 2043

N° de Lot:

1-22083-HYsol 934 11/06/09

33.0 AAC0673

Fibre de verre Miapoxy 66

Commentair Qty.: 0.0002 GALLON(s)/Unit Total : 0.0002 GALLON(s)

Fibre de verre Miapoxy 66

N° de Lot:

1-6872-1

34.0 TRIMAGE 3

TRIMAGE COMPOSITES DART



Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs
TRIMAGE COMPOSITES DART

À l'aide du Gabarit N° DKO-0118 Percer les 3 trous de 1/4" Dia.

À l'aide d'une clé Allen et en faisant bien attention de ne pas abimer les Skins de la pièce, venir faire un dégagement de 1/2" Dia dans le Foam Core en tre les Skin intérieur et extérieur.

À l'aide de masking Tape, masquer le trous de la skin extérieur.

Feuille de Procédé

Client: DART Dart Aerospace Ltd.

Nom Dessin: SIDE DOOR N° D2991-1

Numéro Job: 43821

Numéro Article: DKC134-0050

Numéro Job:



Séq.: Machine ou Opération: Description :

À l'aide d'un mélange de résine Hysol 934NA / Fibre courte Miapoxy 66 et d'une seryngue, venir remplir les dégagements de 1/2" Dia préalablement fait dans le foam Core.

Laisser sécher.

Date: 10-6-09 Sceau:

35.0 TRIMAGE TRIMAGE DE FINITION



Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs
TRIMAGE DE FINITION

À l'aide du gabarit N° DK0-0118 Repercer les 3 trous de 1/4" Dia.

Date: 11-6-09 Sceau:

36.0 AAC0701 Araldite 2043

Commentair Qty.: 0.125 UNITE(s)/Unit Total : 0.125 UNITE(s)
Araldite 2043 N° DE LOT 1-24284-1

37.0 AAC0697 N° D2992-1, Doubler

Commentair Qty.: 2 UNITE(s)/Unit Total : 2 UNITE(s)
N° D2992-1, Doubler N° de Lot: 1-2079-1

38.0 ASSEMBLAGE ASSEMBLAGE GÉNÉRALE DES PIECES



Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs
ASSEMBLAGE GÉNÉRALE DES PIECES

À l'aide de l'adhésif N° Hysol 934NA, assembler le doubler N° D2992-1 sur la pièces de composite selon le dessin.

Date: 11-6-09 Sceau: N.T.

39.0 AAC0683 Dupont Primer N° 7704S

Commentair Qty.: 0.1800 UNITE(s)/Unit Total : 0.1800 UNITE(s)
Dupont Primer N° 7704S N° de Lot: 1-22968-1

40.0 AAC0685 Dupont Activator - Reducer Chromabase N° 7775S

Commentair Qty.: 0.0450 UNITE(s)/Unit Total : 0.0450 UNITE(s)
Dupont Activator - Reducer Chromabase N° 7775S N° de Lot: 1-23133-2

41.0 PRIMER APPLICATION DE PRIMER



Commentair Setup: 0.00Hrs/ Run: 0.0000Hrs Total Run : 0.0000Hrs
APPLICATION DE PRIMER

Appliquer le primer selon I.G. 0008

DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS D350-589 REV. E
AND

INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D350-589 REV. 1
REF CANADIAN STC: SH92-41
REF FAA STC: SH1012NE

D35X-589-041/-042/-043 Side Door Assembly kits at CHG 004 have an additional latch on the trailing edge to provide better fit and security. The side door kits at CHG 004 should be installed per IIN-D350-589 Rev. E, except a total of (4) D2237 striker plates are now installed. The parts list is updated as follows:

ADD:

Qty -041	Qty -042	Qty -043	Part Number	Description
X			D350-589-041	SIDE DOOR ASSEMBLY, LH AS 350
	X		D350-589-042	SIDE DOOR ASSEMBLY, RH AS 350/355
		X	D355-589-043	SIDE DOOR ASSEMBLY, LH AS 355
1	1	1	D2237	Striker Plate
1	1	1	D2585	Latch Clamp
1	1	1	D2586	Latch
1	1	1	D2621	Latch Plate
1	1	1	AN960JD10	Washer
2	2	2	MS20470AD4-5	Rivet
1	1	1	MS21042L3	Nut (or MS21042-3)
1	1	1	MS27039-1-15	Screw

The DSI-9463-011 kit is available for customers with earlier model D35X-589-041/-042/-043 doors to add an additional latch on the trailing edge of the door.

Qty -011	Part Number	Description
X	DSI-9463-011	DOOR LATCH KIT
1	D2237	Striker Plate
1	D2464-1700	Seal
1	D2585	Latch Clamp
1	D2586	Latch
1	D2621	Latch Plate
1	AN960JD10	Washer
2	MS20470AD4-5	Rivet
1	MS21042L3	Nut (or MS21042-3)
1	MS27039-1-15	Screw
2 SQ. FT	N/A	9.7oz 7781 'S' GLASS UNIVERSAL WEAVE

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




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To install the DSI-9463-011 Door Latch Kit:

- 1) Remove the D35X-589-041/-042/-043 door from the aircraft. Remove the D2464-1700 Seal as required to access the composite structure.
- 2) Trim foam core of door 11.0" (280mm) above the aft door latch as shown in Figure 2 of this service instruction. Bevel foam at 45°.
- 3) Apply (2) layers of 9 oz cloth covering the trimmed area, as shown in Section A-A of this service instruction. Acceptable materials for the composite modification are specified in section 7.0 of QSI 037. Cure at room temperature for 24 hours.
- 4) Temporarily locate the D2621 Latch Plate as shown in Figure 3 of this service instruction. Use latch plate as a template and trace the inner rectangle. Cut a hole through the door skin using the traced rectangle to fit a D2586 Latch. Deburr edges of hole and seal edges with potting resin.
- 5) Touch-up the paint finish with one coat of MIL-P-23377 or MIL-P-23377 primer and 2-3 coats of MIL-C-85285 polyurethane paint to match original finish.
- 6) Install D2621 Latch Plate, D2585 Latch Clamp, D2586 Latch, and associated fasteners in accordance with Figure 52-4 of ICA-D350-589.
- 7) Reinstall the door on the aircraft using existing hardware.
- 8) Locate and install a D2237 Striker Plate opposite the new latch location per Figure 52-4 of ICA-D350-589.
- 9) Install the D2464-1700 Seal around the outside edge of the door as shown in Figure 52-4 of ICA-D350-589.
- 10) Check the doors and latches for proper operation by opening and closing the door. Adjust latches as required.

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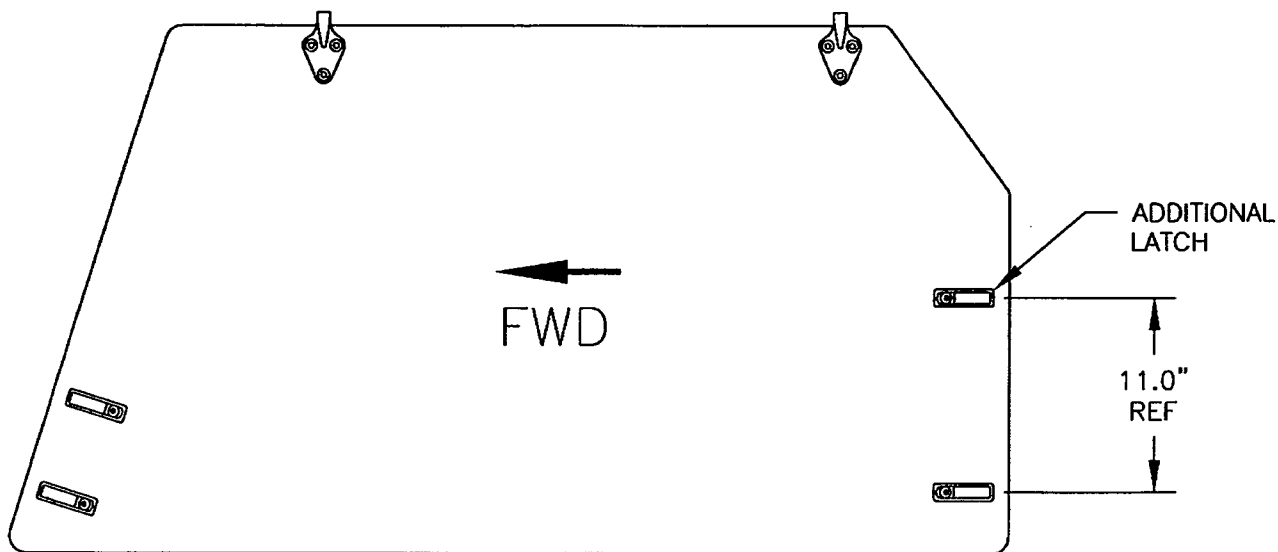


FIGURE 1: D350-589-041 DOOR ASSEMBLY (SHOWN)
D35X-589-042/-043 (SIMILAR)







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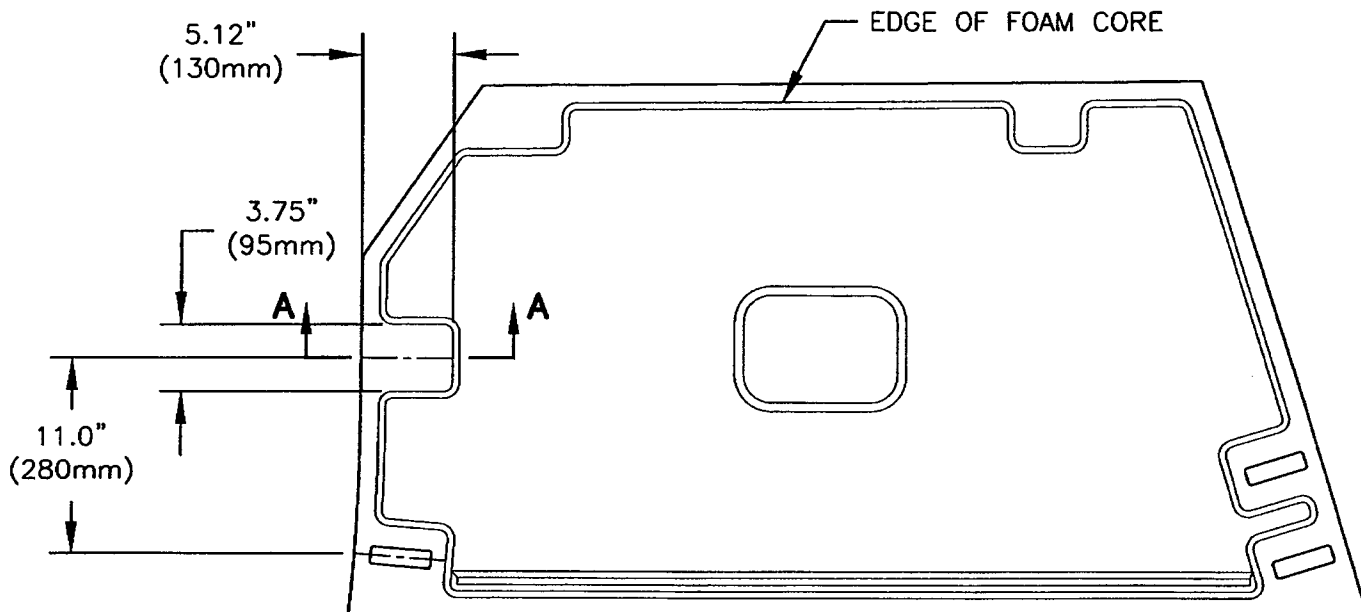
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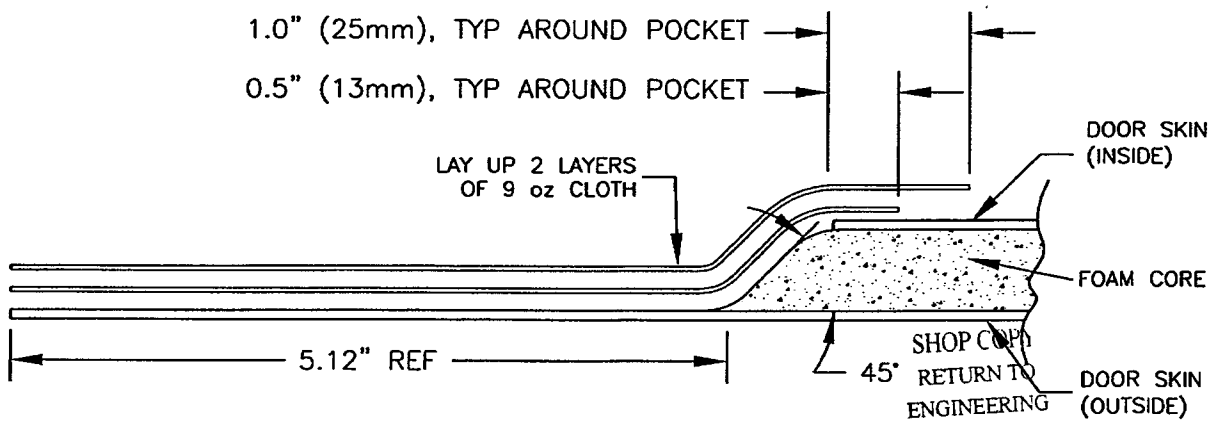
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**FIGURE 2: TRIMMING FOAM CORE
(VIEW LOOKING AT INSIDE OF DOOR)
(-041 SHOWN, -042/-043 SIMILAR)**



SECTION A-A

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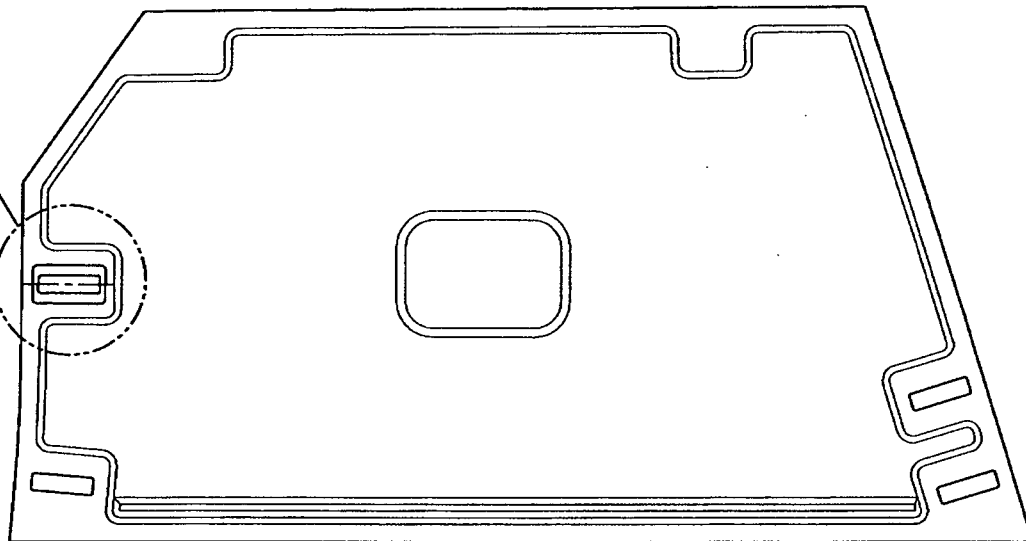
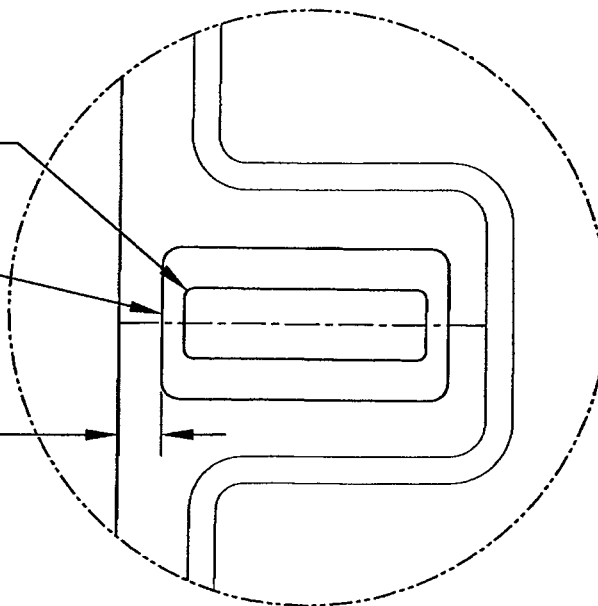


FIGURE 3: CUTTING LATCH HOLE

CUT HOLE THROUGH
SKIN USING D2621 AS
TEMPLATE

D2621 LATCH PLATE

0.60"
(15.2mm)



DETAIL B

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